

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025079**Date Inspected:** 08-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As listed below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 9E PP80 E4 Lifting Lug Holes #1 and 3
2. 10E 11E F Plate Splice
3. 10W 11W C
4. Lamination Scan on Lifting Lug to Floor Beam on Orthotropic Box Girder(OBG) East

1. 9E PP80 E4 Lifting Lug Holes #2 and 4

The QA Inspector observed ABF welder Mike Jiminez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole's (LLH) #1 and 3 located at 9E PP80 E4. Prior to welding the QA Inspector observed QC Inspector Fred Von Hoff inspecting the fit up of the joint and the QA verified the fit up alignment of the two access holes which were deemed acceptable as pertaining to the contract requirements. The QA Inspector observed the QC Inspector monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

2. 10E 11E F Plate Splice

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The QA Inspector observed ABF welder Wen Han Yu ID# 6317 performing SMAW in the 3G vertical position on Plate Splice F located at 10E 11E F1. The QA Inspector observed the QC Inspector Fred Von Hoff monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1040A Rev.1. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

3. 10W 11W C

The QA Inspector randomly observed ABF welders Jorge Lopez ID#6149 and Fred Kaddu ID#2188 utilizing the Plasma Arc Cutting (PAC) process to remove the backing bar from C located at 10W 11W outside of the OBG. The ABF welders applied a 4 inch grinder to remove excess material in order to proceed with back gouging the joint. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

4. Lamination Scan on Lifting Lug to Floor Beam on OBG East

The QA Inspector performed straight beam Ultrasonic Testing on two random lifting lugs in each segment at #1 2E PP15 E3, #4 2E PP15 E4, #1 3E PP22 E3, #2 3E PP22 E4, #3 4E PP27 E3, #3 4E PP27 E4 and #3 5E PP31 E3. The testing appeared to be free of indications and was found to be acceptable. The scan was performed in the defined UT area on drawings ZPM-04-01-001216 to ZPM-04-01-001219 where accessible. The work is in progress and appeared to be in general conformance with submittal 1635 Rev.00.

Summary of Conversations:

At the beginning the shift the QA Inspector met with QC Inspector Pat Swain and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer